


# Work Order ID 82952

**\*82952\***

Page 1

Wednesday, April 11, 2012 2:59:50 PM

Item ID: DSK078 Accept **\*N900040100\*** Setup Start **\*NS1\***  
Revision ID: Stop **\*NS2\***  
Item Name: D2893-1 TURNING DETAIL  
Start Date: 4/11/2012 Start Qty: 10.00 **\*10\*** Cust Item ID:  
Required Date: 4/19/2012 Req'd Qty: 10.00 **\*10\*** Customer:  
Reference:

Approvals: Process Plan:  Date: 12-04-11 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_  
Run Start **\*NR1\***  
Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
DSK078	Rev A								

100 0.00 *off/2 12.4.22* 10 0  
**\*100\***  
Doosan Memo  
Doosan Lathe Turn blank as per Folio FA081  
(4TH AXIS PLUG DT8492)

110 0.00 *off/2 12.4.22* 10 0  
**\*110\***  
QC Memo  
Quality Control QC2- Inspect parts off machine FAI/FAIB

120 0.00 *SL 12-04-25* \_\_\_\_\_  
**\*120\***  
QC Memo  
Quality Control QC8- Inspect parts - second check

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 82952****\*82952\***

Page 2

Wednesday, April 11, 2012 2:59:51 PM

Item ID: DSK078

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Stop

**\*NS2\***

Item Name: D2893-1 TURNING DETAIL

Start Date: 4/11/2012 Start Qty: 10.00

**\*10\***

Cust Item ID:

Required Date: 4/19/2012 Req'd Qty: 10.00

**\*10\***

Customer:

Reference:

Run Start

**\*NR1\***

Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Stop

**\*NR2\***

QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

0.00

**\*130\***

Packaging

Memo

0.00

Packaging

Identify and Stock in Kanban Location: MAT 060SL 12-04-25

140

QC21- Final Inspection - Work Order Release

0.00

**\*140\***

QC

Memo

0.00

Quality Control

12/4/2512-04-25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Wednesday, April 11, 2012 2:59:55 PM

Page 1

Work Order ID: 82952

\*82952\*

Parent Item: DSK078

\*DSK078\*

Parent Item Name: D2893-1 TURNING DETAIL

Start Date: 4/11/2012

Required Date: 4/19/2012

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP rev A. 08.03.13 new issue EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D6104-005		Manufactured	No				Each	22.0000		10			
-----------	--	--------------	----	--	--	--	------	---------	--	----	--	--	--

\*D6104-005\*

Round Billet, 17-4

\*\*

20 12-4-22

Location

Loc Qty

Loc Code

MAT043

20

81922 ✓

20

MAT047

2

80114

2

10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

DART AEROSPACE LTD		Work Order:	82952
Description: Turning Detail for D2893-1		Part Number:	DSK078
Inspection Dwg: DSK078 Rev: A		Page 1 of 1	

### FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
Lathe Section								
A	2.707	2.712		2.711	2.7025	2.708	2.709	2.709
B	4.946	4.966		4.958	4.958	4.958	4.957	4.957
C	3.064	3.084		3.075	3.074	3.074	3.075	3.075
D	0.718	0.738		.726	.726	.726	.726	.726
E	0.090	0.110		.101	.101	.100	.100	.100
F	2.934	2.954		2.945	2.945	2.945	2.944	2.945
G	2.166	2.186		2.176	2.179	2.176	2.177	2.177
H	3.890	3.910		3.900	3.900	3.900	3.900	3.898
I	0.914	0.934		.924	.923	.924	.926	.926
J	0.022	0.042		.032	.032	.032	.032	.032
K	0.109	0.129		.117	.117	.118	.117	.118
L								
M								
N								
O								
P								

Measured by: *amx* Date: 12/04/23

Audited by: *SL* Date: 12-04-25

Prototype Approval: Date:

Rev	Date	Change	Revised by	Approved
A	08.04.22	New Issue	KJ/JLM	<i>[Signature]</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



DART AEROSPACE LTD		Work Order:	82952
Description: Turning Detail for D2893-1		Part Number:	DSK078
Inspection Dwg: DSK078		Rev: A	Page 1 of 1

### FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	16	17	18	19	20
Lathe Section								
A	2.707	2.712		2.709	2.710	2.708	2.708	2.709
B	4.946	4.966		4.957	4.950	4.953	4.957	4.958
C	3.064	3.084		3.075	3.075	3.075	3.075	3.075
D	0.718	0.738		.725	.726	.725	.725	.725
E	0.090	0.110		.100	.100	.100	.100	.100
F	2.934	2.954		2.944	2.944	2.944	2.944	2.944
G	2.166	2.186		2.176	2.178	2.175	2.176	2.177
H	3.890	3.910		3.900	3.899	3.898	3.899	3.899
I	0.914	0.934		.926	.925	.925	.925	.926
J	0.022	0.042		.032	.032	.032	.032	.032
K	0.109	0.129		.117	.118	.118	.118	.119
L								
M								
N								
O								
P								

Measured by: CMK Date: 12/04/23

Audited by: SL Date: 12-04/25

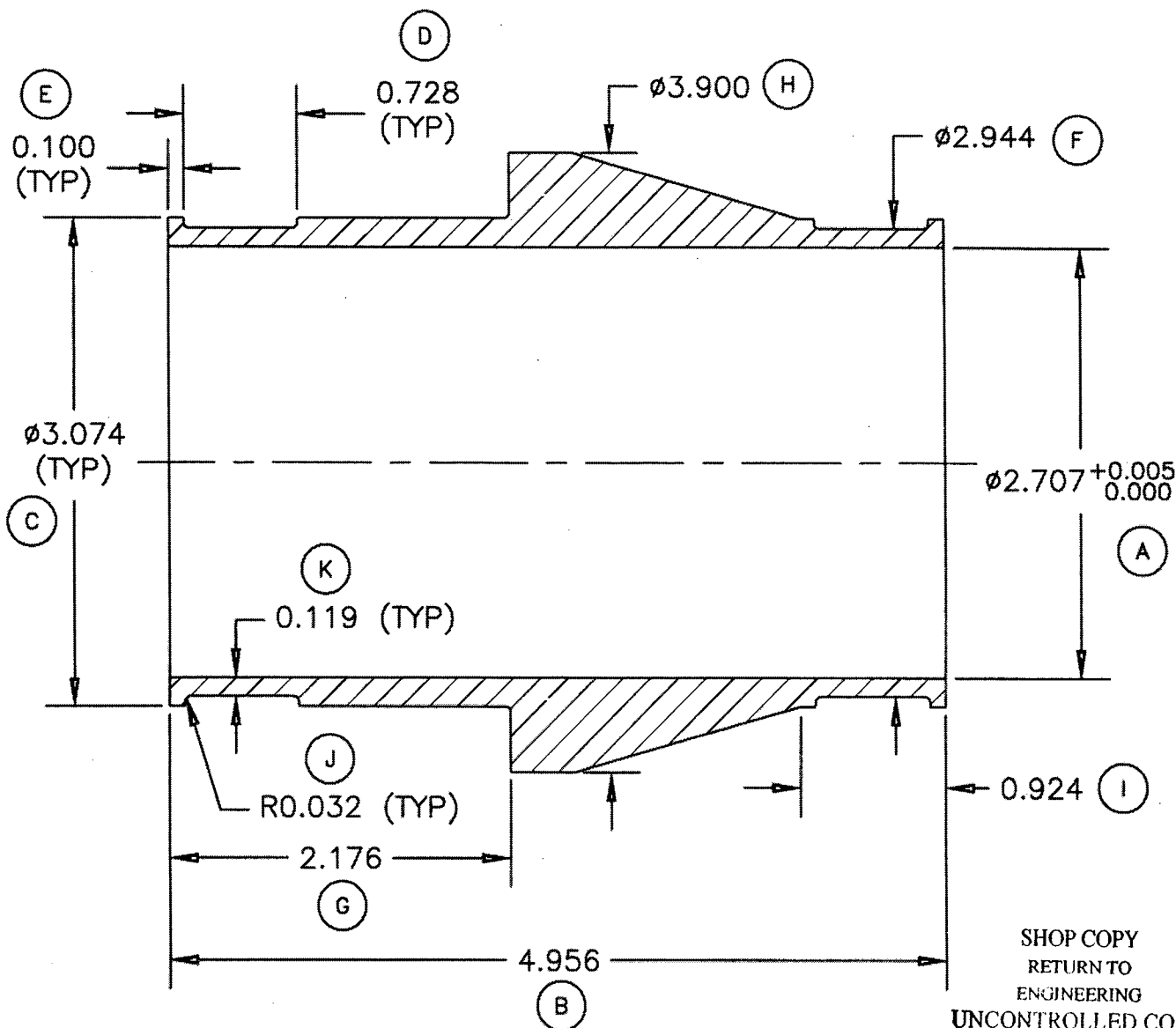
Prototype Approval: \_\_\_\_\_ Date: \_\_\_\_\_

Rev	Date	Change	Revised by	Approved
A	08.04.22	New Issue	KJ/JLM	<u>[Signature]</u>



DESIGN RT	DRAWN BY RT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. DSK 078	REV. A SHEET 1 OF 1
DATE 03.05.20		TITLE TURNING DETAIL FOR D2893-1	SCALE 1:1
A	03.05.20	NEW ISSUE	

RELEASED  
03.07.01



D2893-1 TURNING DETAIL

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 82952

12-04-11

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries